

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000624**Date Inspected:** 14-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2030**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89 Mock-Up**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 89 Meter Mock-Up, Skin-C, Lower Section, Up Side (side A), welds 37 & 39, and Down Side (side B), welds 38 & 40. The Zhenhua Port Machinery Company (ZPMC) QC that was present was An Qingxiang. This Caltrans QA Inspector did witness an Ultrasonic (UT) straight beam and shear wave test that was conducted on the cover pass welds of the Complete Joint Penetration (CJP) sections of welds (area tested was from edge of plate in 0mm to 300mm) on each side and each face of the plate. These tests were performed by ZPMC Level II UT technician Li Li Ming utilizing a Panametrics UT unit S/N 061488510 with a 1.0 inch diameter, 2.5 MHz straight beam transducer and 2.5 MHz, 18mm x 18mm transducers for the 60 and 70 degree wedges using cellulose gum and water for the couplant. No relevant indications were observed during these tests.

Item-2 Horizontal Beam Plate P913-1 to SA24-1 and P913-2 to SA24-2 were being preheated for the welding of the filler passes. The material is 485 and the weld numbers are 9A and 10B. ZPMC QA Li Xiu Yang said that it would be sometime during the morning shift before the welding would began.

Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

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for your project.

Inspected By: Smith,David

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer